

December-17-13 9:06:46 AM

1 10039

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 12/20/13 **Start Qty:** 2.00 ***2***

Customer:

Required Date: 12/20/13 **Req'd Qty:** 2.00 ***~***

Reference:

Run Start *NR1*

Approvals: Process Plan:  Date: 13-12-17

Tooling: _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Rev B

0.00

100

100

Large Fab

0.00

Large Fab

Large Fab

Memo

- 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
- 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842
- 3-Deburr and bevel ends for welding

0.00

110

110

QC6- Inspect dimensions to drawing

0.00

QC

Quality Control

Memo

0.00

120

120

Weld per dwg A/R Aluminum rod Batch: 125127
Large Fab 127845

0.00

Large Fab

Large Fab

Memo

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per
Dwg D2842

2-Grind end cap weld flush

Work Order ID 110039

December-17-13 9:06:46 AM

110039

Page 2

Item ID: D2842-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly, 206 Float

Start Date: 12/20/13 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 12/20/13 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

② 14-03-03 DAS
9
9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

② 14-03-03 DAS
9
9-89

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

2 16-11-35

Work Order ID 110039

December-17-13 9:06:46 AM

110039

Page 3

Item ID: D2842-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly, 206 Float

Start Date: 12/20/13 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 12/20/13 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

2 *[Signature]* *[Stamp]*
DAS
19
9-89
14.03.05

170

Weld per dwg A/R Aluminum rod Batch: 125127 0.00

0.00

170

Large Fab

Memo

0.00

Large Fab

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
2-Grind end cap weld flush.

2 *[Signature]* *[Stamp]*
14.03.05

180

QC10- Inspect visual per QSI004- ground welds

0.00

180

QC

Memo

0.00

Quality Control

② 14.03.05 *[Stamp]*
DAS
9
9-89

Work Order ID 110039

December-17-13 9:06:46 AM

110039

Page 4

Item ID: D2842-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly, 206 Float

Start Date: 12/20/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 12/20/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

② 1403.05

DAS
9
9-89

191

Pressure Wash per QSI005 4.3

0.00

191

HandFinish

Memo

0.00

Hand Finishing

Touch up step with alodine per qsi 005 prior to powder coat

2 14-3-6

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:45
OVEN TEMPERATURE: 320°
FINISH TIME: 11:15

2 14-3-H

DAS
34
9-89

Work Order ID 110039

December-17-13 9:06:46 AM

110039

Page 5

Item ID: D2842-041
 Revision ID:
 Item Name: Step Assembly, 206 Float
 Start Date: 12/20/13 Start Qty: 2.00 *2*
 Required Date: 12/20/13 Req'd Qty: 2.00 *2*
 Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____
 QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control									
220	HandFinishing	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842								
	2-Wing Walk as per Dwg D2842 and QSI 005 4.1								
	Batch: 14128900								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									

DAS
27
9-88

14/3/17

XZ d ll 1403/17

XZ d ll 1408/17

2

Work Order ID 110039

December-17-13 9:06:46 AM

110039

Page 6

Item ID: D2842-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly, 206 Float

Start Date: 12/20/13 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 12/20/13 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00

240

Packaging

Memo

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.00

Quality Control

DAS
06
9-89

MAR 13 2014

PL 14-03-18

AT 14-03-18

Picklist Print

December-17-13 9:06:45 AM

Page 1

Work Order ID: 110039

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 12/20/13

Required Date: 12/20/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			120	Each	98.3900	1	2		14.02.27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		78							
				105575		78							
				WA003		20.39							
				101765		7.92			2				
				81507		4							
				89750		7.87							
				98024		0.6							
D2734 Step End Plate		Manufactured	No			120	Each	219.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		219							
				105712		137							
				80682		6							
				84563		10							
				91761		6							
				99709		60							
D3459-1 Float Step Mounting Plate		Manufactured	No			220	Each	15.0000	2	4		14.02.27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003	B113198	15			2				
				74517		1							
				99037		14			2				

Picklist Print

December-17-13 9:06:45 AM

Page 2

Work Order ID: 110039

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 12/20/13

Required Date: 12/20/13

Start Qty: 2.00

Required Qty: 2.00

D3459-3 Manufactured No
Float Step Mounting Plate

120 Each 13.0000 2

4

14.02.27

Location Loc Qty Loc Code

WA003 8110702 13
103460 8
62956 2
73320 3

4

MS27039C1-07 Purchased No
screw

220 Each 48.0000 3

3

14.02.27

Location Loc Qty Loc Code

ST308 48
124580 6
m125807 4
m127305 38

X 6

NAS1149C0332R Purchased No
WASHER

100 Each 10,701.000 3

3

14.02.27

Location Loc Qty Loc Code

FP001 254
123355 254
GA 1548
125654 1548
ST292 119
123248 18
123759 10
125268 91
st510 8654
m126319 3154
m127306 2500
m127410 3000
ST517 126
124580 126

X 6

December-17-13 9:06:45 AM

Shop Packet Print

Page 2

Picklist Print

December-17-13 9:06:45 AM

Page 3

Work Order ID: 110039

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 12/20/13

Required Date: 12/20/13

Start Qty: 2.00

Required Qty: 2.00

NAS1329C3KB130

Purchased

No

220

Each

25.0000

3

insert

Location

Loc Qty

Loc Code

FP001

25

m126410

25

NAS1515H3L

Purchased

No

220

Each

147.0000

3

Washer

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

107

121556

45

124542

62

11127031.

December-17-13 9:06:45 AM

Shop Packet Print

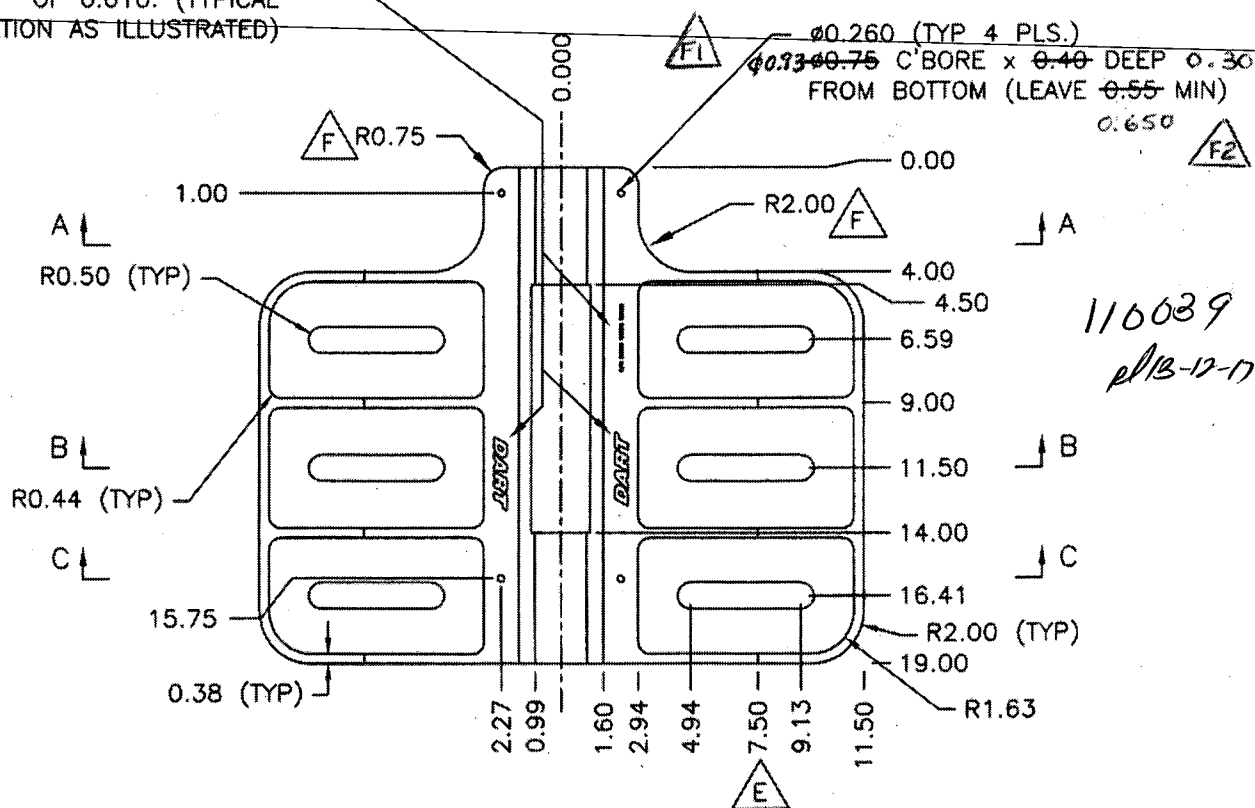
Page 3



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED #	DRAWING NO. D2421	REV. F SHEET 1 OF 2
DATE 01.03.12		TITLE BEARPAW	SCALE 1:7
A	95.04.24	NEW ISSUE	
B	95.11.28	CHANGED NUMBER OF HOLES	
C	97.06.19	ADDED MATERIAL SPECIFICATION	
D	98.08.11	DIM MODIFICATIONS	
E	00.03.01	R1.77 WAS R2.66; ADD R1.85 BORE RELIEF FOR CLAMPS; ADDED DEO 9155	
F	01.03.12	MODIFY FWD END	
F1	03.01.13	Ø0.93 WAS Ø0.75; R0.19 WAS R0.38; Ø0.93 WAS Ø0.75; R0.19 WAS R0.38;	
F2	04.11.03	0.30 WAS 0.40; 0.650 WAS 0.55	

RELEASED
01.03.14

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



SYMMETRIC ABOUT CENTER LINE

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,
1.00" THICK (MACHINE TO 0.950)

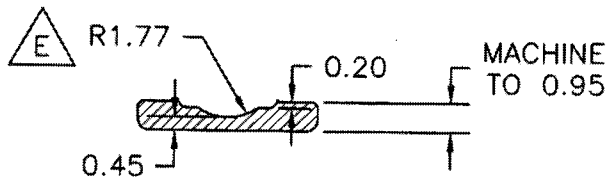
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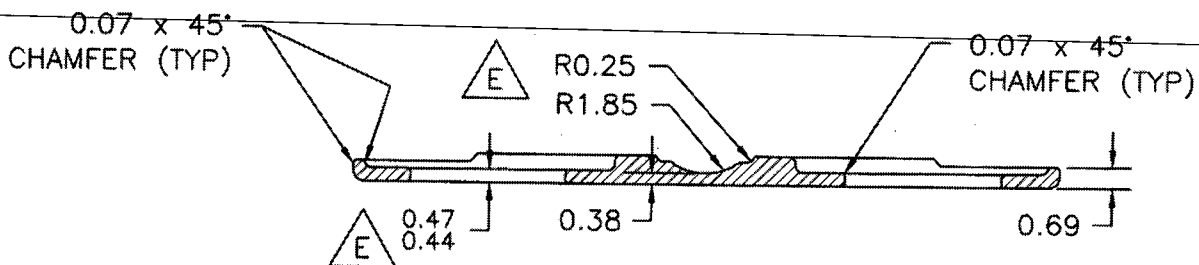


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED #	DRAWING NO. D2421	REV. F SHEET 2 OF 2
DATE 01.03.12		TITLE BEARPAW	SCALE 1:6

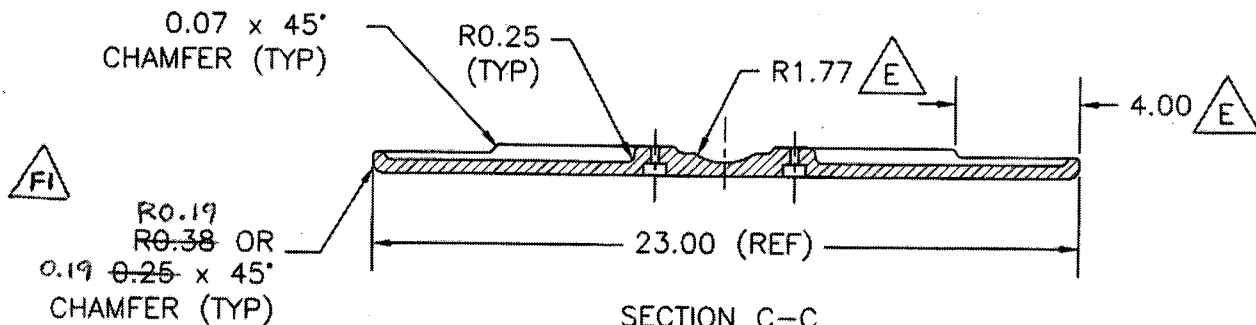
RELEASED
01.03.14 #



SECTION A-A



SECTION B-B



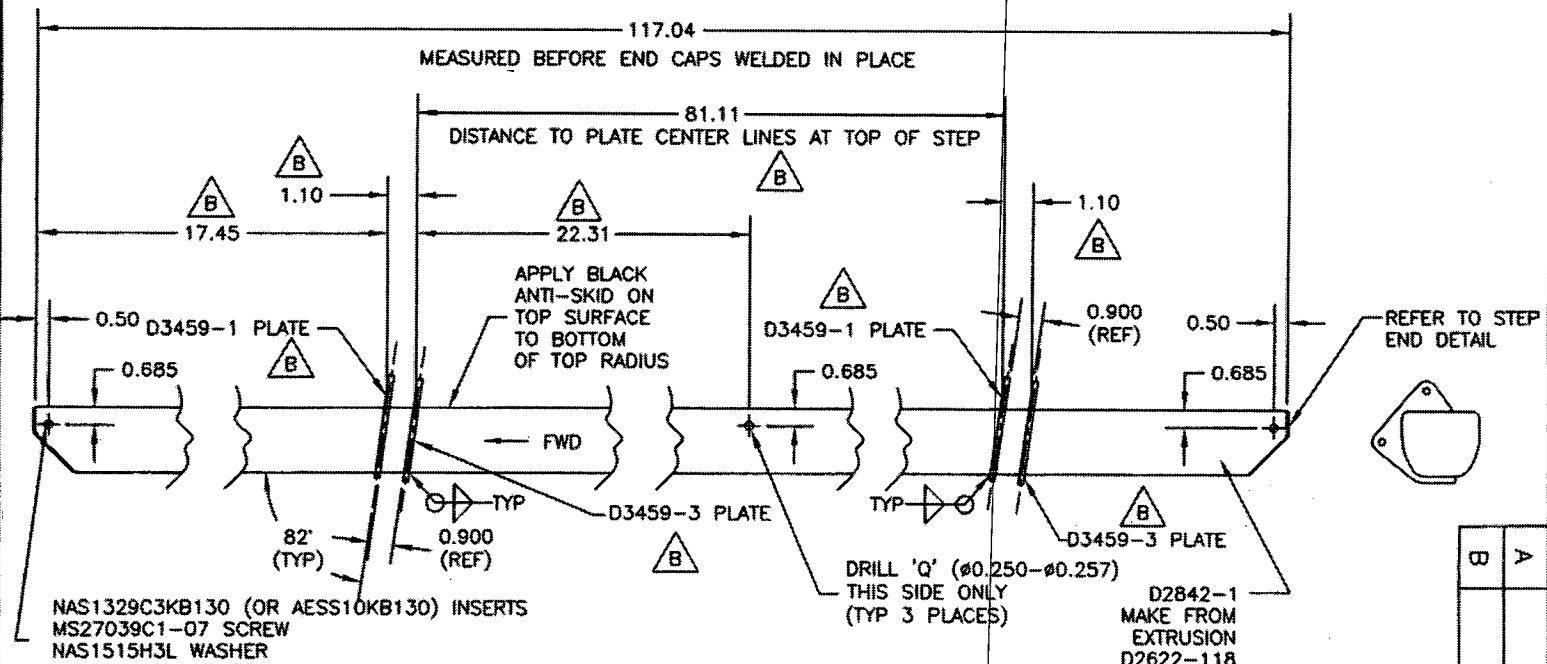
SECTION C-C

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DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
	A		98.10.13	SHEET 1 OF 1
	B		05.09.23	SCALE
			RE-DESIGN, ADD D3459-1/-3	
			206L/407 FLOAT STEP ASSEMBLY	
			NEW ISSUE	



**D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)**

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**TYPICAL STEP END DETAIL
NOT TO SCALE**

RELEASED
05.11.14

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